

### Abstract of the Disclosure

**[0062]** An improved machine for performing a swaging operation includes a mandrel and an expandable collet that are mounted to an actuator such as a conventional pneumatic gun. The mandrel includes a plurality of ramped planar engagement surfaces that are slidably engageable with a plurality of planar reaction surfaces on deflectable segments of the collet. The planar nature of the engagement surfaces and the reaction surfaces avoids unwanted deflection of the segments that would otherwise turn the segments into cutting tools, such as would occur if the surfaces were of certain other shapes. The mandrel is rotatably mounted to the pneumatic gun whereby the engagement surfaces are self-aligning with the reaction surfaces during an initial stage of a swaging operation.